

POWERCRETE J
GEL, RE-COAT AND CURING TIME CHART

This chart provides approximate Gel, Re-coat and Curing Time based on conditions and procedures outlined below.

1. Keep Part A @ 77°F (25°C) for hand application and 140°F (60°C) for spray application, keep Part B @ 77°F (25°C) and warm/cool the High Density Polyethylene Sheet to be used as substrate to the designated temperature.
2. Mix Part A and Part B thoroughly, and pour the mixture onto the substrate.
3. Set the mixtures in oven/refrigerator to maintain the temperature of testing.
4. Touch with finger to check gel and dry time every two minutes.
5. Cool down/warm up the coating mixture to room temperature, 77°F (25°C) and measure the hardness with a Durometer Type "D" that has stabilized after 3 seconds and remains in a constant reading of Shore 65 or Shore 75.

WARNING: UNDER 40°F (4°C) COATING MIXTURE IS FROZEN AND NO CHEMICAL REACTION WILL OCCUR

| Testing Temperature | Application Procedure | Gel Time | Re-Coat Time Window (in minutes from application time of previous coating pass) | Dry Time | 65 Shore "D" Reading | 75 Shore "D" Reading |
|---------------------|-----------------------|----------|--|---------------|----------------------|----------------------|
| 40°F (4°C) | Hand | 180 min. | 170th-----360th | 9 hr. | 96 hr. | 120 hr. |
| | Spray | 130 min. | 120th-----305th | 8 hr. | 80 hr. | 97 hr. |
| 50°F (10°C) | Hand | 110 min. | 100th-----235th | 6 hr. | 75 hr. | 95 hr. |
| | Spray | 50 min. | 40th-----175th | 5 hr. | 60 hr. | 72 hr. |
| 60°F (16°C) | Hand | 62 min. | 57th-----150th | 4 hr. | 20 hr. | 28 hr. |
| | Spray | 39 min. | 34th-----125th | 3 hr. 30 min. | 16 hr. | 19 hr. |
| 70°F (21°C) | Hand | 52 min. | 47th-----116th | 3 hr. 30 min. | 8 hr. | 10 hr. |
| | Spray | 31 min. | 26th-----83rd | 2 hr. 15 min. | 6 hr. 15 min. | 7 hr. 20 min. |
| 80°F (27°C) | Hand | 30 min. | 25th-----75th | 2 hr. | 4 hr. 45 min. | 5 hr. 30 min. |
| | Spray | 29 min. | 24th-----67th | 1 hr. 45 min. | 4 hr. 10 min. | 5 hr. 10 min. |
| 90°F (32°C) | Hand | 25 min. | 20th-----58th | 1 hr. 30 min. | 2 hr. 50 min. | 4 hr. 20 min. |
| | Spray | 21 min. | 16th-----41th | 1 hr. | 2 hr. | 3 hr. 15 min. |
| 100°F (38°C) | Hand | 18 min. | 15th-----37th | 55 min. | 2 hr. | 2 hr. 50 min. |
| | Spray | 17 min. | 14th-----31st | 45 min. | 1 hr. 35 min. | 2 hr. |
| 110°F (43°C) | Hand | 16 min. | 13th-----31st | 45 min. | 1 hr. 40 min. | 2 hr. 15 min. |
| | Spray | 16 min. | 13th--28th | 40 min. | 1 hr. 15 min. | 1 hr. 30 min. |
| 120°F (49°C) | Hand | 15 min. | 12th--28th | 40 min. | 1 hr. 20 min. | 1 hr. 45 min. |
| | Spray | 13 min. | 10th--24th | 35 min. | 58 min. | 1 hr. 15 min. |
| 130°F (54°C) | Hand | 14 min. | 11th--25th | 35 min. | 56 min. | 1 hr. 20 min. |
| | Spray | 12 min. | 9th-18th | 25 min. | 36 min. | 49 min. |
| 140°F (60°C) | Hand | 13 min. | 10th-18th | 25 min. | 40 min. | 1 hr. |
| | Spray | 10 min. | 8th-15th | 20 min. | 32 min. | 40 min. |
| 150°F (66°C) | Hand | 10 min. | 8th-15th | 20 min. | 38 min. | 55 min. |
| | Spray | 9 min. | 7th-10th | 13 min. | 19 min. | 24 min. |

NOTE: Coating temperatures lower than 77°F (25°C) will give a false hardness reading. When a grinder is being used, a cured coating will give out dust particles, while an uncured coating will melt like gum. Shore D Hardness of 65 = able for transportation Shore D hardness of 75 = able for backfill.